



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3400-00-1

Job Sheet 170575



Part No: RBE350A93-3400-00-1

Job Qty: 6 ea

Part Name: Guide



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: RBE350A93-3400-00 REV 3 IPP REV A 18-01-16 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/26/18	0.00	0.00	Start Up Machining-4		
120	CNC Lathe	6 pcs		2/27/18	1.00	6.00	MORI SL-154		
130	QC	6 pcs		2/27/18	0.00	0.00	QC2 Machining-5		
140	QC	6 pcs		2/27/18	0.00	0.00	QC8 Machining-5		
170	Outsource	6 pcs		2/27/18	0.00	0.00	Outsource12	P0039387	18-03-21
180	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging2		18-03-21
190	QC	6 pcs		2/27/18	0.00	0.00	QC6		11 MAR 2 2018
200	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging3-2	GH	11 MAR 2 2018
210	QC21-SA	6 Ea		2/27/18	0.00	0.00	QC21		11 MAR 2 2018

Part Op 120 - 1-Machine as per folio FB732 FOLIO REV: _____ DWG REV: _____ 2-Deburr 3-Engrave part
Descriptions: number and/or batch number And/or T/N number as required Using Marktronic engraver as per DWG.

170 - Issue P/O to Groupe Altech; PO 049387 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
Conformity is required
180 - Receive
200 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140H-R1.375	4140 Round Bar 1.375	2.4000 ft (.4 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.



Container No: S052474



Part: RBE350A93-3400-00-1

Job No: 170575

Serial No/Batch: S052474

Revision: 3

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 1/17/18 11:26 AM Dart.lajeunesse.marie

DML 3-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

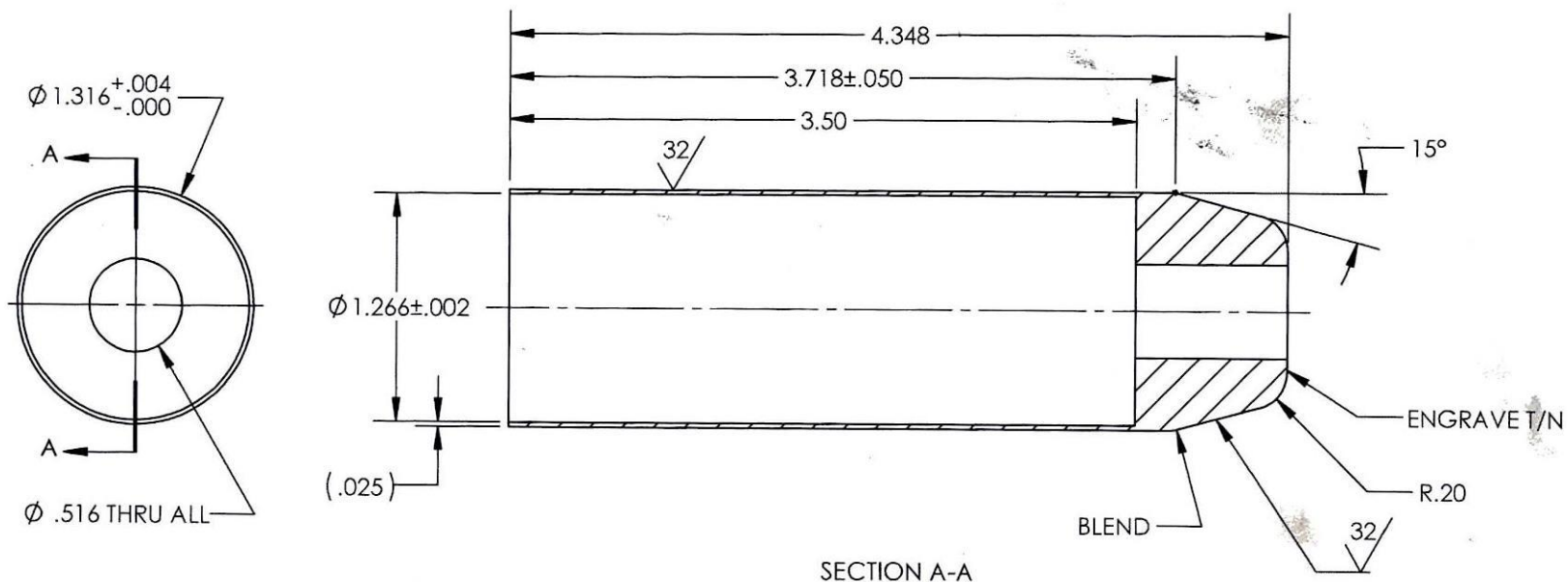
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		CH'D THIMBLE TO GUIDE AND MATERIAL FROM 4140 Q&T, ADDED BLEND NOTE PER D.W.	9/15/2011	RJC	DW
3	17-0172	-1 CH'D ENGRAVE NOTE WAS ENGRAVE T/N, S/N, & "MADE IN USA" TO FIT IS ENGRAVE T/N. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. CH'D MATL FROM 4140 TO 4140/4142. DELETED DIMS (.630), 75°. ADDED DIMS 3.718±.050, 15°. CH'D DIM WAS R.200 IS R.20.	7/13/2017	DPD	JAG



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170575 MWS
1801-18

(-1)
GUIDE

4.365

DART AEROSPACE	
TITLE DRIVESHAFT THIMBLE	
DWG NO. RBE350A93-3400-00-1	REV 3
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125 ✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 07/13/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/21/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/26/2017	EUROCOPTER 350/355
SCALE 1:1	DATE 10/15/2009
SHEET 2 OF 2	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039387

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039387
PO Date: 3/22/18
Due Date: 4/2/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173998	C3-19-1	Lifting Bolt -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required	Firmed	4/2/18	5 pcs	0 pcs	5 pcs	\$18.00/pcs	\$90.00
						✓ 5x		At 18/03/27		
2	169529	RBT400325	Socket Tail Boom Nut -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/2/18	1 pcs	0 pcs	1 pcs	\$3.1578947/pcs	\$3.16
						✓ 1x		At 18/03/27		
3	170586	RBE350A94-3700-A-05	Foot -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/2/18	20 pcs	0 pcs	20 pcs	\$3.157894740/pcs	\$63.16
						✓ 20x		At 18/03/27		
4	172461	RBE350A94-3700-A-05	Foot -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/2/18	10 pcs	0 pcs	10 pcs	\$3.157894740/pcs	\$31.58
						✓ 10x		At 18/03/27		

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	170575	RBE350A93-3400-00-1	Guide -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/2/18	7 pcs	0 pcs	7 pcs	\$3.157894740/pcs	\$22.11
Grand Total:										\$210.00
Order Notes Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

DAS
11
9-89

Plex 3/23/18 11:10 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(007818-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007818-1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax:.

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
27-Mar-2018		Aman		P0039387				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	C3-19-1 Rev.	C3-19-1 TYPE 2 SC2 0.0003	ZINC	5	5	0	0	0
			CH					
2	RBT400325 Rev.	RBT400325 01 -OXIDE BLACK [OXIDE BLACK	OXIDE-BLACK	1	1	0	0	0
			CH					
3	RBE350A94-3700-A-05 Rev.	RBE350A94-3700-A-05 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK	20	20	0	0	0
			CH					
4	RBE350A94-3700-A-05 Rev.	RBE350A94-3700-A-05 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK	10	10	0	0	0
			CH					
5	RBE350A93-3400-00-1 Rev.	RBE350A93-3400-00-1 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK	7	7	0	0	0
			CH					

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.